

Date: Tuesday, 12/20/2005 3:31:03 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SKIDTUBE ASSEMBLY RH
Job Number	: 25315		
Estimate Number	: 10265		
P.O. Number	: N/A	Part Number	: D350636012
This Issue	: 12/20/2005 S.O. No. : N/A	Drawing Number	: D2750 REV C1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 12/20/2005 Type : LANDING GEAR	Drawing Revision	: C1
Previous Run	: 25314	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 1/20/2006
Checked & Approved By	: <u>W</u>	Qty:	1 Um: Each
Comment	: Est Rev:1 02.09.25 Rearranged procedure steps KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG 001

DT 06/01/13

2.0	D26003BENT	Extrusion Bent
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent) B25384 Pm' 06-03-09

3.0	D2744	Fwd Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2744 Cap B 24672 BE 06-05-25

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-3-Bent aft end to length as per Dwg D2750 Mark cut line using Jig DT 8150. Deburr end Pm' 06-03-09

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1) and mark fwd end for cutting using Drill Jig DT 8150. Second side of Detail B to be Drilled using DT 8330 Pm' 06-03-09

3-Open up holes for Detail B, D and 2 aft 0.500" AE holes to finished size as per Dwg D2750 and DEO 9133 Do not open any 0.625" AE holes to finished size Pm' 06-05-24

4-Drill pilot holes as per Dwg D2750 (Sheet 3, D2750-2), mark Fwd end for cutting using Drill Jig Pm' 06-05-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Tuesday, 12/20/2005 3:31:03 PM
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Job Number: 25315

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

DT8150, then drill both sides.

5-Open holes as per detail "P" To 500", then Drill pilot holes to detail "B" using DT8329

Make sure that wearplate holes are on bottom of tube**

6-Open holes to .500" as per detail "B&C".

7-Open holes to .375" as per detail "D"

8-Cut fwd end of tube as per Dwg D2750

9-Drill pilot holes for wearplates using DT 8108 Open holes to 0.297" and Open holes per Dwg D2750 detail A

10-Open holes to .590" as per detail "D".

11-Deburr

12-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod

13-Grind welds flush as per Dwg D2750

pmc 06-05-29

m19101 BE 06-05-25 ①
BE 06-05-25 ①

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

25 06-05-29

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

QC5-DP 06-5-29

PD 06-05-29

7.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2739

Web

B26385 Pmc 06-05-29 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:31:04 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25315

Part Number: D350636012

Job Number:



Seq. #: Machine Or Operation: Description :

8.0 D2743 Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 D2743 Crossbolt spacer *B-25838 BE 06-05-30 (1)*

9.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open 0.625" \pm holes and countersink for welding crossbolt spacers as per Dwg D2750. Do not use cutting oil *pm' 06-05-29 (1)*

2-Deburr and blow out all chips from inside of tube *pm' 06-05-29 (1)*

3-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

Sikaflex expire date: *06-11-01*

4-Weld crossbolt spacers D2743 as per Dwg D2750 and QSI 004

A/R Aluminum Rod

5-Grind welds flush as per Dwg D2750

6-Spot face ground handling holes \pm 0.750" (8 places)

7-Deburr holes

10.0 QC5/9

WELD INSPECTION



PD 06-06-05

Comment: Inspect weld and work to Step 20 *06-05-31 (1)*

11.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

N/A

DC

06-06-09 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25315

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D27422	Blade Fitting, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2742-2	Blade Fitting, LH	B24640

14.0	AN835A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN8-35A	Bolt	m18576

15.0	AN960JD816	1/2" washer, Alum
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960JD816	Washer	m6956

16.0	MS21083N8	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21083N8	Nut	m19099

17.0	D26483	Wearpad
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Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
5	D2648-3	Wearpad	B25904

18.0	D265613	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-13	Wearplate	D25914

a.m 06-06-12 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25315

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	D265635	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-35	Wearplate	B26206

20.0	D2746	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2746	Wearplate	B25841

21.0	ALS41032225	Insert
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Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
46	ALS4-1032-225✓	Insert	m100499
	(or AKS4-1032-225)		
	(or ALS7-1032-225)		
	(or AKS7-1032-225)		

22.0	AN960JD10L	Washer
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Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
42	AN960JD10L	Washer	m18235

23.0	AN35A	Bolt
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	AN3-5A	Bolt	m15205

a.m 06-06-12 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25315

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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24.0

AN36A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	M100274

25.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	D2745	Bushing	M24879

26.0

AN644A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN6-44A	Bolt	M19471

27.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	MS21042L6	Nut (or -6)	M17614

28.0

AN332A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-32A	Bolt	M19513

a-m 06-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25315

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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29.0	A3235020935	Washer - Countersunk
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	A3235-020-935	Plug	<u>m18369</u>

30.0	MS21042L3	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	MS21042L3	Nut	<u>m100393</u>

31.0	AN36A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	<u>m10074</u>

32.0	AN960JD10	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN960JD10	Washer	<u>m16066</u>

a.m 06-06-12 (1)

33.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Assemble as per Dwg D2750 Page 4 Detail P. Install D2742-2 and seal with Sikaflex adhesive prior to installing aft most wearpad. Ensure holes are properly aligned.

A/R Sikaflex-291 m101126

Sikaflex expire date: 06-06-06

2-Install inserts & wearplates as per Dwg. D2750 Detail K & Q and IIN-D350-636 Page 4. Use a drop of Sikaflex in insert holes before installing wearpad/wearplate. AN3-6A bolts are installed AFT.

A/R Sikaflex-291 m101126

Sikaflex expire date: 06-11-06

a.m 06-06-12 (8)

PTD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-06-09	33.2	QCS - Inspect Insert threads.	<i>[Signature]</i>	06-06-12	42		<i>[Signature]</i> 06-06-09

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25315

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Install D2745 Bushing as per Dwg. D2750 Detail M

4-Install A3235-020-935 Plug as per Dwg. D2750 Detail L

5-Install AN3-6A Bolt as per Dwg. D2750 Detail Q

DEM 16-06-12

PTO

34.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DL 09/06/13 (1)

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

36.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

1 D2741

Blade

B25938

✓

37.0

AN960JD816

1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 AN960JD816

Washer

M6956

✓

38.0

MS21083N8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

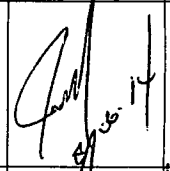
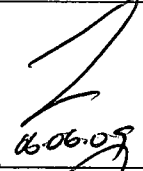
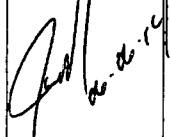
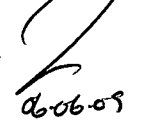
Batch

2 MS21083N8

Nut

M100993

✓

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-06-09	33.6	QCS - Inspect for foreign objects in tube						
06-06-09	33.7	Assemble D2742-2 as per Dwg. Sika Flex -251 B# _____ exp. _____						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25315

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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39.0	AN816A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty	Part Number	Description	Batch
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2	AN8-16A	Bolt	M5760 V
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806/06/13 (1)

40.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

806/06/14 (1)

41.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-012

Rev D

806/06/14 (1)

42.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

806/06/14 (1)

Job Completion



U 860614

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN <i>DAH</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>DAH</i>	APPROVED <i>KE</i>	DRAWING NO. D2750	REV. C SHEET 1 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
C1	<i>CP</i> 05.01.20	CHANGE QTY WEARSHOE HOLES, AS MANUFACTURED	

RELEASED
98.12.16 DS

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
3	3	3	3	D2648-3	WEARPAD
2	2	2	2	D2648-5	WEARPAD
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
1		1		D2742-1	BLADE FITTING, LH
	1		1	D2742-2	BLADE FITTING, RH
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
8	8			A3235-020-935	PLUG
40	40	40	40	AN3-5A	BOLT
8	8	8	8	AN3-6A	BOLT
4	4			AN3-32A	BOLT
4	4	4	4	AN6-44A	BOLT
2	2	2	2	AN8-16A	BOLT
1	1	1	1	AN8-35A	BOLT
3	3	3	3	MS21083N8	NUT
4	4			MS21042L3 OR MS21042-3	NUT
4	4	4	4	MS21042L6 OR MS21042-6	NUT
4	4	4	4	AN960JD10	WASHER
44	44	44	44	AN960JD10L	WASHER
4	4	4	4	AN960JD816	WASHER
44 42	44 42	44 42	44 42	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

EFFECTIVE	DEOS
820 4133 DS	820 4137 DS
98.01.19 DS	98.10.21 DS

UNCONTROLLED
SUBJECT TO
WITHDRAWAL



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. C SHEET 2 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

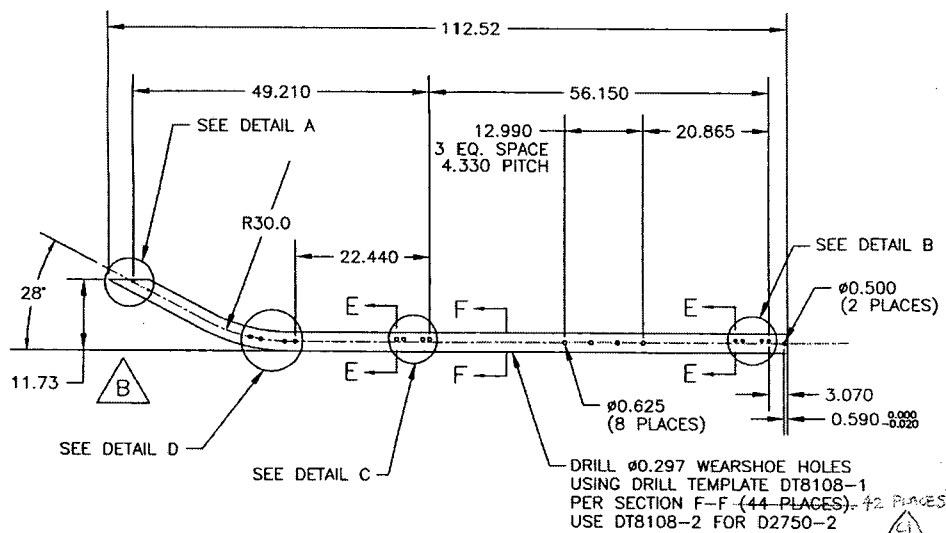
GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
3. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
4. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E AND F-F.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
7. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2734 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
8. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4.
9. D2742-1 (OR D2742-2) BLADE FITTING AND AN3-5A/AN3-6A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.

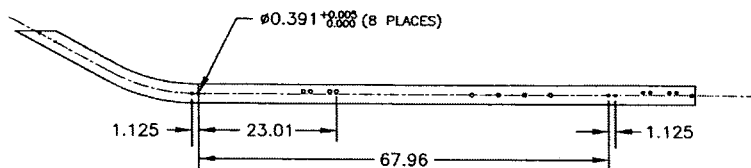
EFFECTIVE	DEOs
DEO 4133 98.01.19 DS	DEO 4157 99.10.21 DS

RELEASED
49.12.161003

SUBJECT TO
WITH FOR

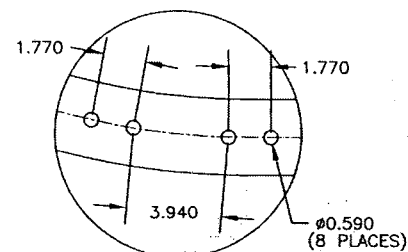
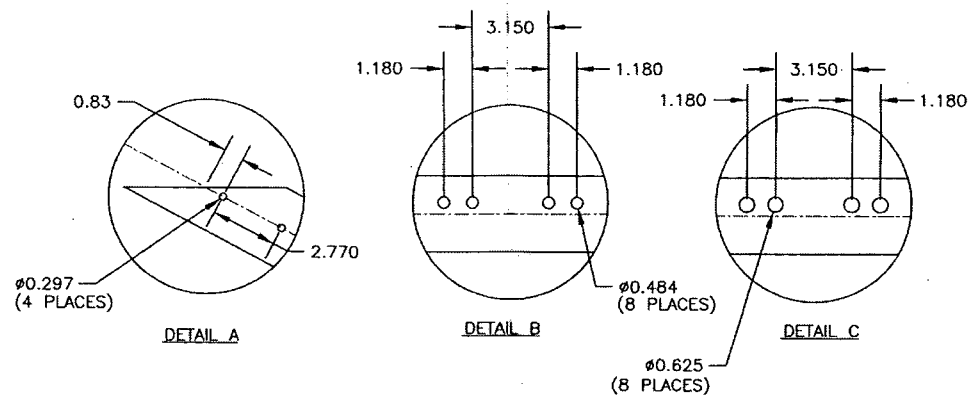


D2750-1 LH SKIDTUBE (SHOWN)
D2750-2 RH SKIDTUBE (OPPOSITE)

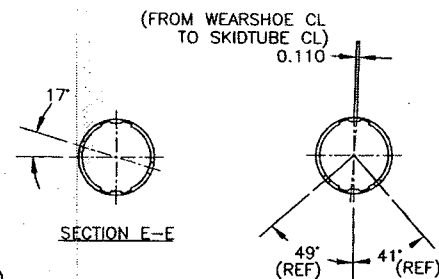


D2750-3 LH SKIDTUBE (SHOWN)
D2750-4 RH SKIDTUBE (OPPOSITE)

D2750-3/-4 ARE THE SAME AS D2750-1/-2 EXCEPT THAT DETAIL D HOLES ARE REPLACED BY HOLE CONFIGURATION GIVEN ABOVE.



(ALL DIMENSIONS ARE STRAIGHT LINE DIMENSIONS)



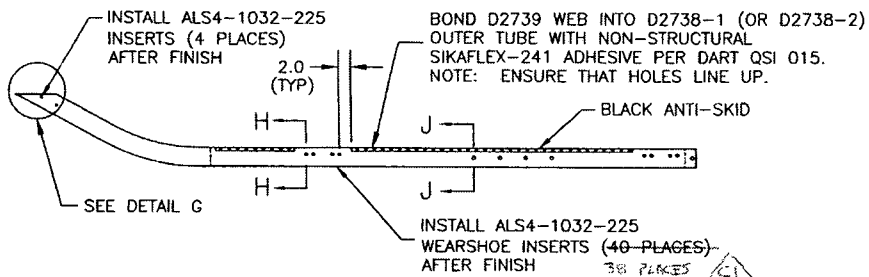
RELEASED
98.12.16 DS

EFFECTIVE	DEOS
000 9133 98.01.19 DS	000 9157 99.02.21 DS

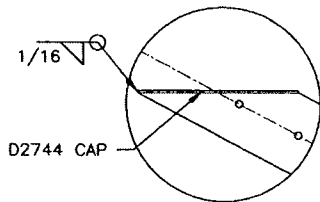
DESIGN 98	DRAWN BY JP	DART DART AEROSPACE USA, INC. BELLVILLE, TX
CHECKED 98	APPROVED KE	
DATE 98.11.18	DRAWING NO. D2750	REV. C SHEET 3 OF 4
	TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20

WORK COPY
FOR OUT NO 10
25315

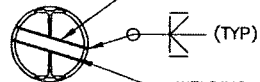
D2750-1/-2/-3/-4 WELDING DETAIL
(FLOAT ATTACHMENT HOLES REMOVED)
D2750-1/-3 SHOWN (D2750-2/-4 OPPOSITE)



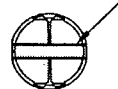
DETAIL G



SECTION H-H D2743 SPACER (REF)



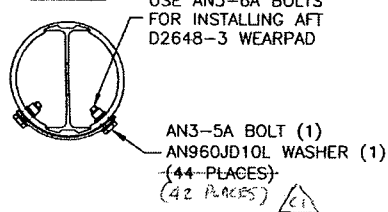
SECTION J-J



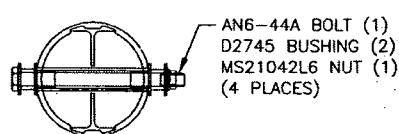
WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

DETAIL K



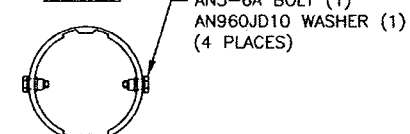
DETAIL M



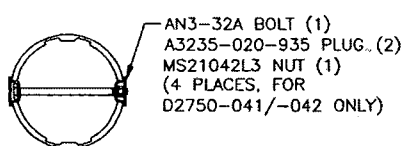
DETAIL P



DETAIL Q



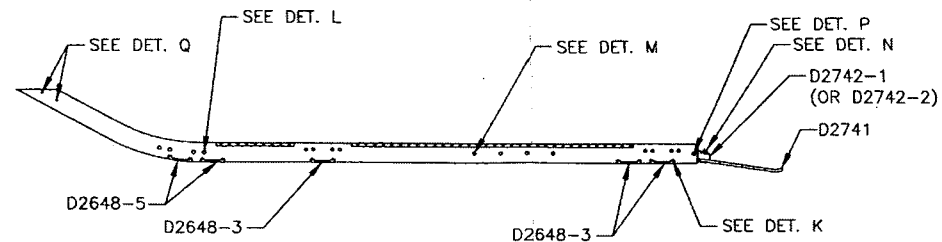
DETAIL L



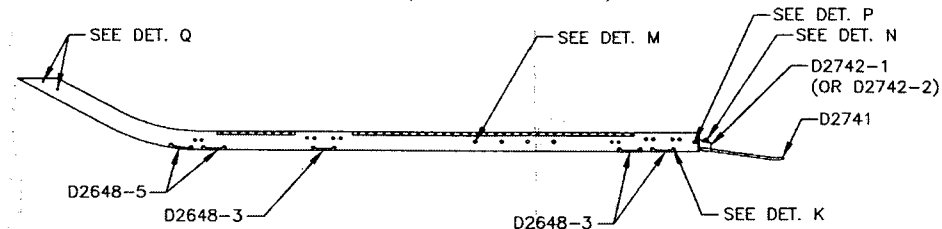
DETAIL N



D2750-041/-042 ASSEMBLY
D2750-041 SHOWN (D2750-042 OPPOSITE)



D2750-043/-044 ASSEMBLY
D2750-043 SHOWN (D2750-044 OPPOSITE)



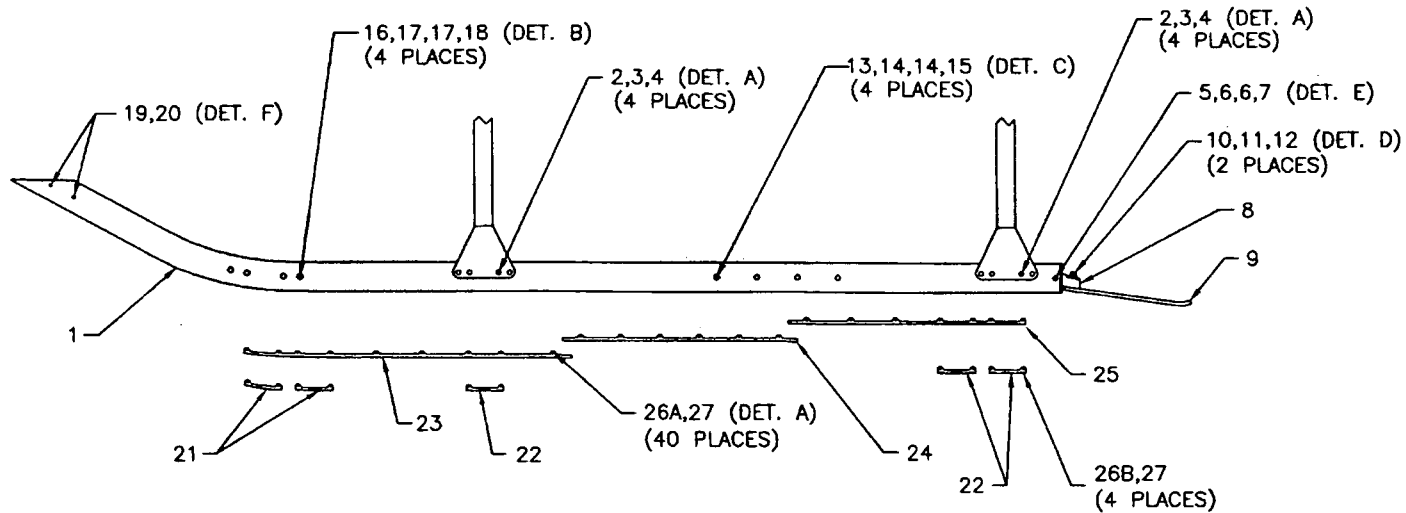
RELEASED
98.12.16 DS

EFFECTIVE	DEOs
DES 9133 98.01.19 DS	DES 9157 99.10.21 DS

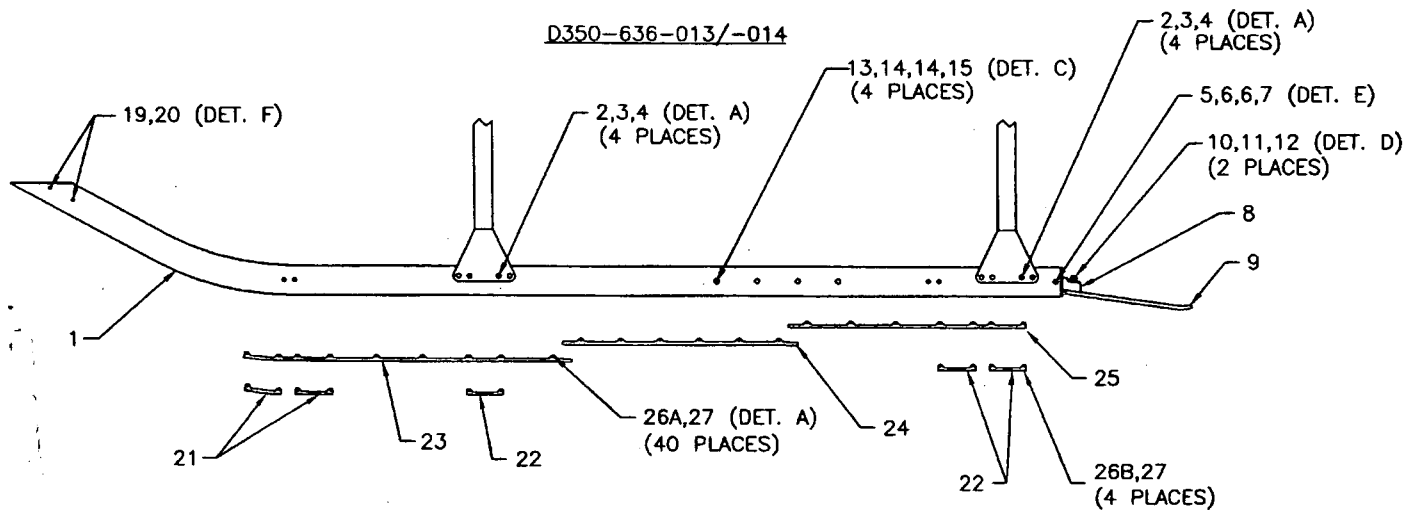
DESIGN [Signature]	DRAWN BY CP	DART DART AEROSPACE USA, INC. BELLINGHAM, WA	REV. C
CHECKED [Signature]	APPROVED KE	DRAWING NO. D2750	SHEET 4 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20

25315
DART
AEROSPACE
USA, INC.

D350-636-011/-012



D350-636-013/-014



NO. 25315
Date: 98.11.19
Revision: C
WORK

Thursday, 07/09/2006 7:44:30 AM
Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D350-636-012

Job Number : 28376

Estimate Number : 10804

P.O. Number : *N/A*This Issue : 07/09/2006 S.O. No. : *N/A*

Prsht Rev : NC

First Issue : 01/09/2006 Type : RMA

Previous Run : 00015

Written By : *L*Checked & Approved By : *L*

Comment :

Part Number : D350636012

Drawing Number : RTN499

Project Number : *N/A*

Drawing Revision :

Material :

Due Date : 08/09/2006

Qty: 1 Um: Each

Additional Product

DART		TEL : 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D350-636-012	CHG	CHG001
DESC	Skidtube RH	STC	SH99-7
LOT	B25315	STC	SR00646SE
MODEL	AS350/355	STC	
US PATENT # 5735483 CANADA FOREIGN PATENTS PENDING		MADE IN CANADA	

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 D350636012

Skidtube RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Skidtube RH

ORIGINAL B/N 25315

2.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT RTN 499

3.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP

USING NEW B/N

NEW LABELS AND PAPERWORK REQUIRED

*PHG 1**REV D**B 6/9/14 ①*

4.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

INSPECT LEVEL 21

*06/09/2006**DANA Piche**N 06-09-26*

Job Completion

*Add 1 x D2741**AN8-16A**M5760**MS21083N8**M100993**AN960-ID816**M6956**D2741**B 27968**DB**06/09/14*